



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5955
Job Sheet 189124


Part No: D5955

Job Qty: 6 pcs

Part Name: Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/18/19

Job Tracking No:

Due Date: 2/16/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:F 05/26/06.12.06 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	HAAS 4 Axis	6 pcs	2/16/19		0.32	16.67	HAAS - 1			19/4/18
							HAAS - 2			
							HAAS - 3			
							HAAS - 4			
110	QC 1	6 pcs	2/16/19		0.00	0.00	QC 1 - 14			19/4/18
							QC 1 - 35			
							QC 1 - 8			
							QC 1 - 9			
120	QC 8	6 pcs	2/16/19		0.00	0.00	QC 8 - 12			
							QC 8 - 14			
							QC 8 - 17			
							QC 8 - 20			
							QC 8 - 25			
							QC 8 - 3			
							QC 8 - 32			
							QC 8 - 33			
							QC 8 - 35			
							QC 8 - 38			
							QC 8 - 39			
							QC 8 - 4			
							QC 8 - 44			
							QC 8 - 45			
							QC 8 - 49			
							QC 8 - 58			
							QC 8 - 8			
							QC 8 - 9			
							QC 8 - 68			
							QC 8 - 67			
							QC 8 - 1 (A)			
130	Handfinish - 1-1 Chemical-	6	2/16/19		0.00	0.52	Handfinish - 1 - 1 -			



Container No: S170193



Part: D5955
Job No: 189124
Serial No/Batch: S170193
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Newbury, ON K64 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/06/19



Container No: S170193



Part: D5955

Job No: 189124

Serial No/Batch: S170193

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/06/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

B4B

pcs

B4B

Handfinish - 1 - 2 -

B4B

Handfinish - 1 - 3 -

B4B

Handfinish - 1 - 4 -

B4B

Handfinish - 1 - 5 -

B4B

Handfinish - 1 - 6 -

B4B

Handfinish - 1 - 7 -

B4B

Handfinish - 1 - 8 -

B4B

Handfinish - 1 - 9 -

B4B

Handfinish - 1 - 10 -

B4B

D.R 19/04/11

Handfinish - 1 - 11 -

B4B

Handfinish - 1 - 12 -

B4B

Handfinish - 1 - 13 -

B4B

Handfinish - 1 - 14 -

B4B

Handfinish - 1 - 15 -

B4B

Handfinish - 1 - 16 -

B4B

Handfinish - 1 - 17 -

B4B

Handfinish - 1 - 18 -

B4B

Handfinish - 1 - 19 -

B4B

Handfinish - 1 - 20 -

B4B

Handfinish - 1 - 21 -

B4B

Handfinish - 1 - 22 -

B4B

140 Powdercoat - 1 White Gl(A)-
B4B

6
pcs

2/16/19

0.00 0.28

Powdercoat - 1 - B4B

Powdercoat - 2 - B4B

Powdercoat - 3 - B4B

Powdercoat - 4 - B4B

BK 19-04-15

150 QC 3

6
pcs

2/16/19

0.00 0.00

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 26

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 38

QC 3 - 41

QC 3 - 51

QC 3 - 58

				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	DAS
				QC 3 - 9	APR 15 2019 40
160 Packaging 3-1 - Stock - B4B	6	2/16/19	0.00 0.00	Packaging 3 - 1 - B4B	9-89
	pcs			Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	5-399 8/1 APR 16 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	6	2/16/19	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21 APR 16 2019
Part Op 100 - (HAAS CNC Vertical Machine), 1-Machine as per folio D5955,Ensure Batch Number is entered					
Descriptions: 110 - (QC1- Inspection performed by CMM), Inspect on CMM as per folio CMMA018.					
120 - (QC8- Inspect parts - second check)					
130 - (Chemical Conversion Coat per QSI005 4.1)					
140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), START TIME: _____					
150 - (QC3- Inspect Part Finish)					
160 - (Identify as per dwg & Stock Location:_____)					
170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-013	Saddle Billet	6 pcs (1 ea)	100-HAAS 4 Axis	5038652 x 2	
				5082697 x 5	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	D6101-013	6	24	0	

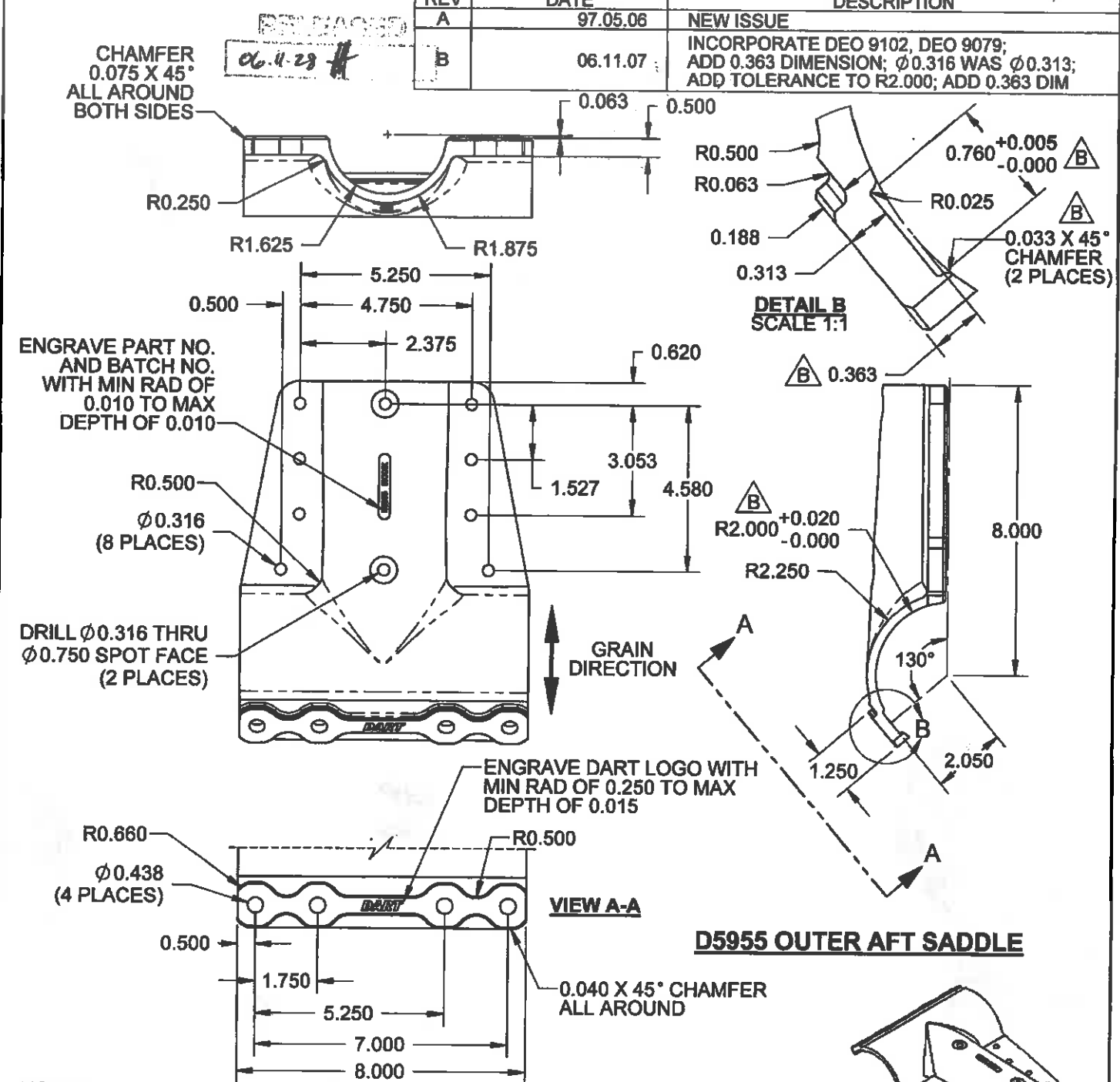
Part Specifications

Specifications could not be found.

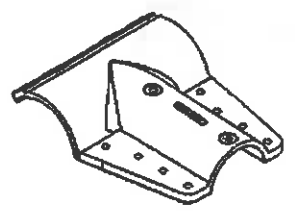
Plex 1/18/19 11:45 AM Dart.Macdonald.Dara



DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5955	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER AFT SADDLE	SCALE 1:4	
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø 0.316 WAS Ø 0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	



- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12 (MAKE FROM D6101-013 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES 0.010 TO 0.020



ISOMETRIC VIEW
SCALE 1:8

Entered:

Date:

NCR No.

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



Job: 189124
Part No. D5955

DISPOSITION
Rework ☐
Scrap ☒
Use-as-is ☐

Skid-tube ☐
Machining ☒
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

DEPARTMENT/PROCESS
Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date : APR 08 2019

Sequence #:

100 HAAS

QTY Affected :

1

MRB (CSI042)

Description Work Order Deviation

Disposition

top of island to bore (R2.006) distance
is under tolerance at 0.345 ^{+/- .010} (0.363)

-scrap and replace.

D 19-04-11

Completed By

WJ 19/4/18

Lead hand / Supervisor

D.P 19-04-08

QC / QA Coordinator

68

9-89

APR 08 2019

DAS

68

9-89

Root Cause

Operator ☒
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Other/Details: ☐

Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☒
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

DART AEROSPACE LTD		Work Order:	
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.747	4.747	4.747	4.747		
G	0.315	0.322		0.315	0.316	0.315	0.315		
H	1.522	1.532		1.526	1.526	1.526	1.526		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.315	0.315	0.315	0.315		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.501	0.501	0.500	0.500		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.001	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.312	0.312	0.312	0.312		
R	0.760	0.765		0.760	0.761	0.761	0.761		
S	0.490	0.510		0.502	0.504	0.505	0.501		
T	1.625	1.645		1.625	1.625	1.625	1.625		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		0.033	0.033	0.033	0.037		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>VH</u>	Audited by: <u>canary</u>
Date: <u>19/04/11</u>	Date: <u>19/04/11</u>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	

DART AEROSPACE LTD		Work Order:	18924
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.240	5.260		5.250	5.250				
F	4.745	4.755		4.747	4.747				
G	0.315	0.322		0.315	0.315				
H	1.522	1.532		1.526	1.526				
I	3.048	3.058		3.053	3.053				
J	4.575	4.585		4.580	4.580				
K	0.315	0.322		0.315	0.315				
L	0.495	0.505		0.500	0.500				
M	0.490	0.510		0.500	0.500				
N	1.865	1.885		1.875	1.875				
O	7.990	8.010		7.999	7.999				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		0.312	0.312				
R	0.760	0.765		0.762	0.761				
S	0.490	0.510		0.503	0.502				
T	1.625	1.645		1.635	1.635				
U	2.000	2.020		2.000	2.000				
V	0.023	0.043							
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	19/4/18	Audited by:	19/04/11
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	